

Work Order ID 88949

Saturday, August 11, 2012 12:41:04 PM

88949

Page 1

Item ID: D350-591-121

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step, LH

Start Date: 8/14/2012 Start Qty: 4.00

4 3

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4 3

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/08/13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2351

Rev E

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

0.00

0.00

110

110

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

0.00

0.00

3 12/08/13 MLJ 12-11-6

(3)

4 12-10-23

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Page 2

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Item ID: D350-591-121

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, LH

Stop ***NS2***

Start Date: 8/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.								- DC 12/10/29
130		0.00							
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							12-10-29
Quality Control									
140		0.00							
140	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel Fwd and Aft end for welding								
	2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033								
	A/RAluminum Rod 122341								
	3-Do not Grind Flush 122431								



DP

12-10-29

3

Ø

12-10-29

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Item ID: D350-591-121

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, LH

Stop ***NS2***

Start Date: 8/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4

Customer:

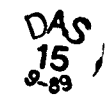
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									



12 10-31

3

12-10-31

3

3

12-11-1

Work Order ID 88949

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Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, LH
 Start Date: 8/14/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/24/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC Inspect Part Finish Memo	0.00 0.00				3	0		DAS 23 8-99
190 *190* Large Fab Large Fab	Large Fab Memo 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod 122358 3-Grind end cap flush per dwg D2351	0.00 0.00				3	0		16 12-11-02
220 *220* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				3	12-11-2		DAS 09 8-88

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Item ID: D350-591-121

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, LH

Stop *NS2*

Start Date: 8/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Chemical Conversion Coat per QSI005 4.1	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo	0.00							
Powder Coating									

3 12-11-2



3X 0

mk

12/11/05

3X 0

mk

12/11/05

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00
3200 F
12:30

m122878

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Item ID: D350-591-121

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, LH

Stop ***NS2***

Start Date: 8/14/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/24/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

Wing Walk as per dwg QSI005 4.4 Batch 22589 0.00

260

HandFinish

Memo

0.00

Hand Finishing

3 ϕ BL 12-11-5.

270

QC3- Inspect Part Finish

0.00

270

QC

Memo

0.00

Quality Control

2AS
15
2-89
12 11 08

3

280

Pick Kit

0.00

280

Packaging

Memo

0.00

Packaging

3 12/11/06 JB

Work Order ID 88949

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Item ID: D350-591-121 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, LH
 Start Date: 8/14/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 8/24/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 *290* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				3			
300 *300* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D350-591-121 Location: 60 PPP Rev:	0.00 0.00				30			12/11/75
310 *310* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/11/8 78 MCS 12-11-07

Picklist Print

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Page 1

Work Order ID: 88949

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 8/14/2012

Required Date: 8/24/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			110	Each	56.5000	0.5	2.1052632		8/12/10.23	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		56.5							
				60307		2							
				80803		54.5							
D2850-1 End Bracket		Manufactured	No			140	Each	7.0000	1	4		8/12/10.29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA016		7							
				77101		7							
D2582 Step Leg Assembly		Manufactured	No			190	Each	2.0000	1	4		8/12/11.01	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA014		2							
				72828		2							
MS20600-AD4W3 Cherry Rivets		Purchased	No			190	Each	1,470.0000	16	64		8/12/11.01	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				311		582							
				122452		582							
				ST314		284							
				122151		284							
				ST321		471							
				111636		36							
				117601		3							
				118626		200							
				120308		232							
				WA018		133							
				107939		133							

Picklist Print

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Work Order ID: 88949

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 8/14/2012

Required Date: 8/24/2012

Start Qty: 4.00

Required Qty: 4.00

D2673-34 Manufactured No 210 Each 43.0000 1 4 12.11.01

End Plate

Location Loc Qty Loc Code

WA 43
84535 43

AN4-16A

Purchased No

Bolt

290 Each 127.0000

123352 20 12.11.01

Location Loc Qty Loc Code

ST357 63
122416 63
ST358 64
120498 14
121541 50

SMB 3y

S

D2856-400

Manufactured No

Abrasion Strip

cut (1) at 7.20"

290 f 202.4425

0.6 24 20 12.11.06

Location Loc Qty Loc Code

ST403 96.998
81875 96.998
ST409 105.4445
63735 0.6696
68076 0.3149
71164 8.46
86905 96

SMB 3y

AN960JD416

NAS1149D0463J Purchased

Washer

No

290 Each 29.0000

86905 24 20 12.11.06

Location Loc Qty Loc Code

ST351 29
116289 8
119097 21

SMB 3y

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 88949

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 8/14/2012

Required Date: 8/24/2012

Start Qty: 4.00

Required Qty: 4.00

D2230-1

Lug

Manufactured No

290 Each 186.0000

89415³ ✓ 10 8/11/06

Smb 3y

Location Loc Qty Loc Code

ST480 186

84136 186

AN3-37A

Bolt

Purchased No

290 Each 417.0000

86 ✓ 20 8/11/06

Smb 3y

Location Loc Qty Loc Code

ST353 417

117619 4

119086 413

MS2104213

Nut

Purchased No

290 Each 3,345.0000

119086 2 123265⁸⁶ ✓ 20 8/11/06

Smb 3y

Location Loc Qty Loc Code

316 831

122452 831

ST300 771

117885 32

119017 601

119075 138

ST317 1743

122141 1743

AN4-13A

Bolt

Purchased No

290 Each 1,123.0000

129 ✓ 20 12/11/06

Smb 3y

Location Loc Qty Loc Code

ST356 500

122416 500

ST357 623

120187 19

120770 12

121652 588

122063 4

122416

Picklist Print

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Page 4

Work Order ID: 88949

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 8/14/2012

Required Date: 8/24/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Nut

Purchased No

290 Each 5,460.0000

3

123021¹² JB

Smb 3Y

Location

Loc Qty

Loc Code

314	5000
122452	5000
ST300	460
104248	1
116823	4
119075	116
121011	193
121444	146

D2230-3

Lug

Smb 3X

Manufactured No

290 Each 184.0000

1

89082³ JB

Location

Loc Qty

Loc Code

ST472	184
84134	184

D2732-030

Rubber Cushion
cut (2) at 3.00"

Smb 3X

Manufactured No

290 Each 42.0000

2

83560⁸ JB

Location

Loc Qty

Loc Code

ST402	2
84498	2
ST415	40
88776	40

AN960JD10

Washer

NAS1149D0363J

Purchased No

290 Each 0.0000

4

123248¹⁶ JB 12/11/06

Smb 3X

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

SHIP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 88549 MJS
12/08/13

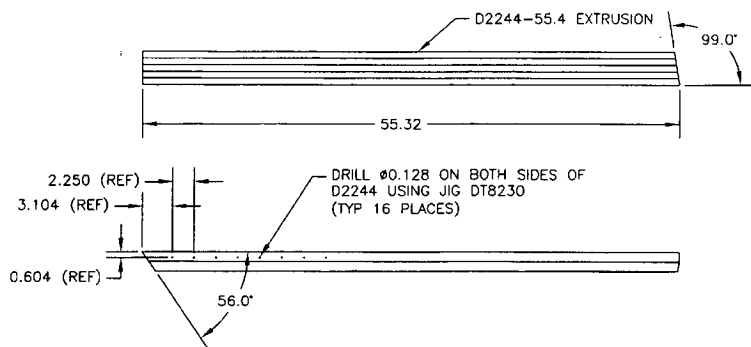
RELEASED
05.11.28**UNDER REVIEW**
ECN 1105
07.11.29
P02.1102.263

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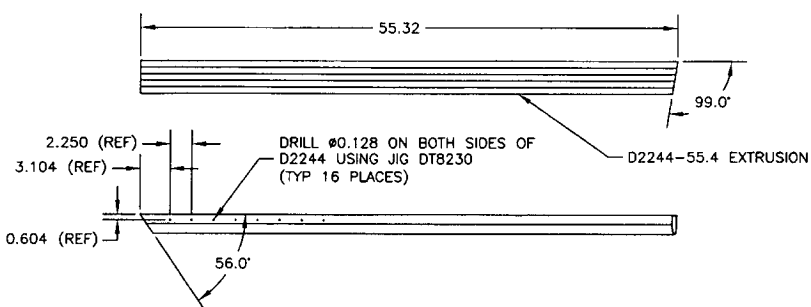
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28949

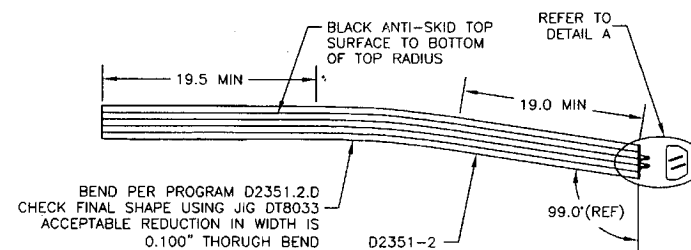
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



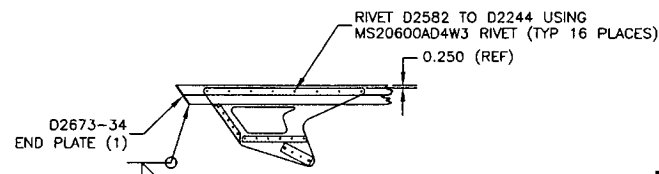
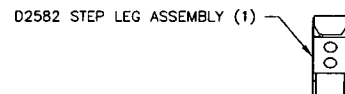
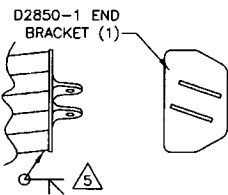
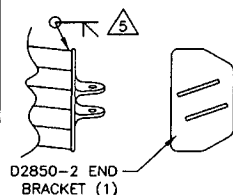
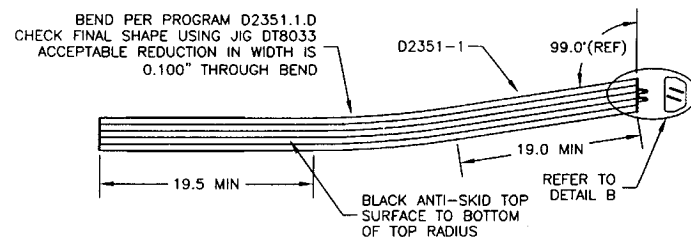
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



GENERAL NOTES

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 5) CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

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DESIGN KE	DRAWN BY PH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12

RELEASED
05.11.28

UNDER REVIEW
03.11.14

REFERENCE ONLY 5MB

DART AEROSPACE LTD.

D350-591
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5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	Heli-Access-Step ™, Long Step – High Skid
	X					D350-591-113	Heli-Access-Step ™, Short Step – High Skid
		X				D350-591-115	Heli-Access-Step ™, Short Step – Low Skid
			X			D350-591-117A	Heli-Access-Step ™, Pre-Flight Step
				X		D350-591-119	Heli-Access-Step ™, Long Step – Low Skid
					X	D350-591-133	Heli-Access-Step ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-122	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-123	Heli-Access-Step ™, Short Step – Low Skid, LH
			X	D350-591-124	Heli-Access-Step ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: **G**
Date: 08.10.06

REFERENCE ONLY 5MB

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT







The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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